

**Work Order ID 71278**

Friday, June 24, 2011 3:45:27 PM



Page 1

Item ID: D3325-041

Accept



Setup Start



Revision ID:

Item Name: Basket Lid Assembly

Stop



Start Date: 6/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:



Date: 11-06-27 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

Draw Nbr	Revision Nbr
D3325	Rev B

100



Large Fab

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

*1      S      6/24/05*

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

*S 6/24/05*

121



HandFinish

Pressure Wash per QSI005 4.3

0.00

0.00

*K O M 11/07/05*

Hand Finishing

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



Powdercoat

Powder Coating

W W 7745

Operation  
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

Memo 8:15 0.00  
 1ST COAT: 8:45 400°F  
 START TIME: \_\_\_\_\_  
 OVEN TEMPERATURE: \_\_\_\_\_  
 FINISH TIME: \_\_\_\_\_

X J M-L 11/07/05

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:  
 START TIME: \_\_\_\_\_  
 OVEN TEMPERATURE: \_\_\_\_\_  
 FINISH TIME: \_\_\_\_\_

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo 0.00

1 6 BL 11-8-5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/  
Work Center ID**
**Operation  
Description**
**Set Up/  
Run Hours**
**Tool ID**
**Tool #**
**Plan  
Code**
**Accept  
Qty**
**Reject  
Qty**
**Reject  
Number**
**Insp.  
Stamp**

150



Packaging

Packaging

Identify as per dwg & Stock Location: *G-A*

0.00

*JS/107/05 ①*

Memo

*w/o  
71276*

0.00

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*11/15/05*
*MC*
*11-07-05*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Friday, June 24, 2011 3:45:34 PM

Page 1  
2

Work Order ID: 71278



Parent Item: D3325-041



Parent Item Name: Basket Lid Assembly

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 05.02.09 New issue KJ/JLM  
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3328-1 		Manufactured	No			100	Each	27.0000	2	2		<i>11.06.28</i>	
Basket Hinge							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				WA005	33871			27				<i>(2)</i>	
								27					
D3349-1 		Manufactured	No			100	Each	32.0000	2	2		<i>11.06.28</i>	
Spacer Bushing							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				WA005	34205			32				<i>(2)</i>	
					44401			4					
								28					
D3352-1 		Manufactured	No			100	Each	16.0000	1	1		<i>11.06.28</i>	
Label Plate							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				WA005	41925			16				<i>(2)</i>	
								16					
D3367-1 		Manufactured	No			100	Each	28.0000	2	2		<i>11.06.28</i>	
Mounting Bracket							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				WA005	43228			28				<i>(2)</i>	
								28					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Page 2

Friday, June 24, 2011 3:45:35 PM

Work Order ID: 71278



Parent Item: D3325-041



Parent Item Name: Basket Lid Assembly

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035

Purchased No

100

f

414.3443

20.5416

21.62274



SAD 11-06-27

4130 Square tube .500 x .500 x .035w

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT034	414.3443	
109127	216	
109385	15.75	
112786	182.5943	21.62274

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY

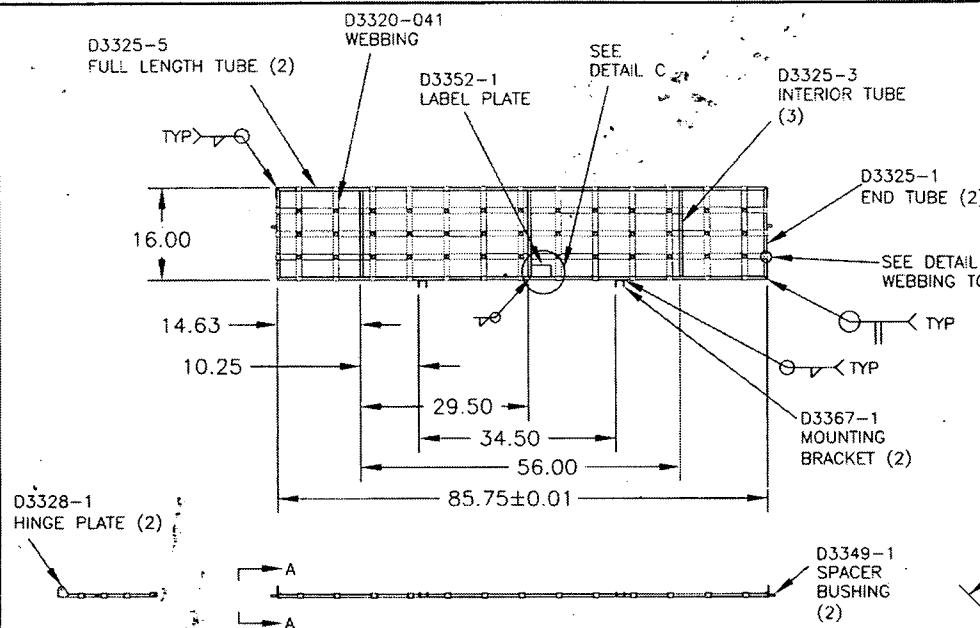
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 337128

*PL11-06-27*



**D3325-041 BASKET LID ASSEMBLY**

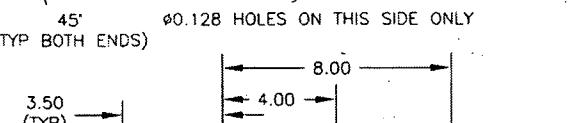
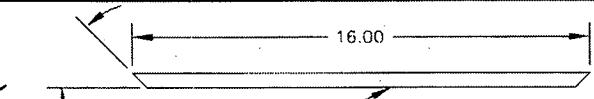
- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 (PRIOR TO INSTALLATION OF D3320-041)
- 2) WELD PER DART QSI 004
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**PARTS LIST FOR D3325-041 BASKET LID ASSEMBLY**

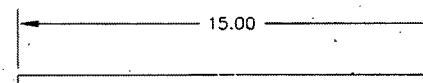
Part No.	Quantity	Description
D2729-1	1	PRODUCT ID LABEL
D3320-041	1	WEBBING
D3325-1	2	END TUBE
D3325-3	3	INTERIOR TUBE
D3325-5	2	FULL LENGTH TUBE
D328-	2	HINGE PLATE
D3349-1	2	SPACER BUSHING
D3351-1	1	PLACARD
D3352-1	1	LABEL PLATE
D3367-1	2	MOUNTING BRACKET
MS20600AD4W3	32	RIVET
AN860UD9	32	WASHER

RELEASED  
*05-04-28*

DEO ATTACHED



**D3325-1 END TUBE**  
(SCALE 1:4)



**D3325-3 INTERIOR TUBE**  
(SCALE 1:4)



**D3325-1 SPACER BUSHING**  
(TYP BOTH ENDS)

45°  
(TYP BOTH ENDS)

0.128 HOLES ON THIS SIDE ONLY



**D3325-1 SPACER BUSHING**  
(TYP BOTH ENDS)

45°  
(TYP BOTH ENDS)

0.128+0.005 -0.000

(TYP 13 HOLES, EQUALLY SPACED,  
THRU INSIDE TUBE WALL ONLY)



**D3325-5 FULL LENGTH TUBE**  
(NOT TO SCALE)

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE, AMS-T-6736, 1/2" X 0.035 (REF. DART SPEC M4130N-TSO.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	05.04.25	CHANGE RIVET AND HOLE DIAMETER
A	04.10.21	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD. HALIFAX, NS, CANADA
<i>PH</i>	<i>PH</i>	
CHECKED	APPROVED	DRAWING NO. D3325
<i>PH</i>	<i>PH</i>	DATE 05.04.25
		TITLE BASKET LID ASSEMBLY
		SCALE 1:20

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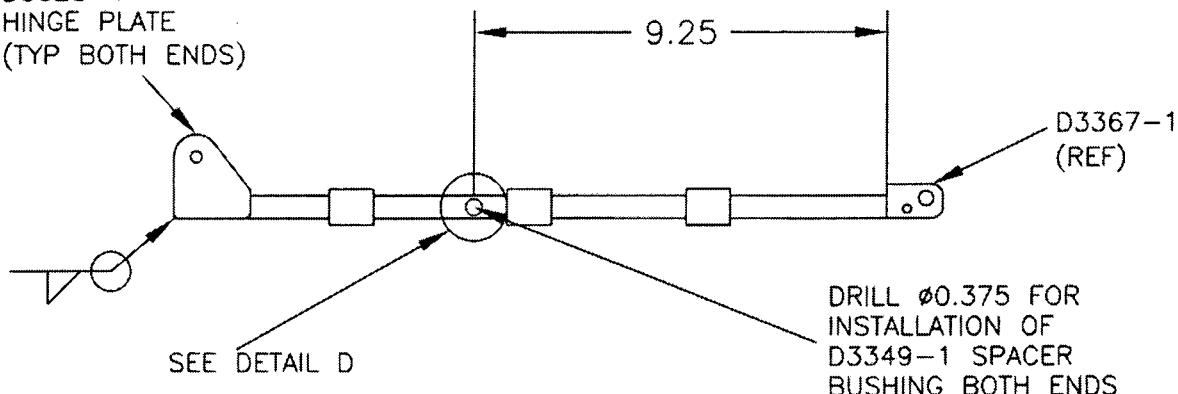
REV. B

SHEET 1 OF 3



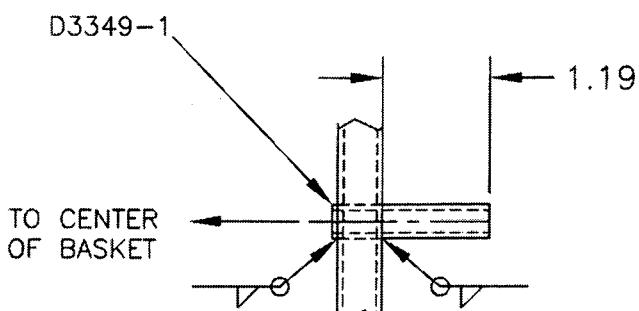
DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3325	REV. B SHEET 2 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

D3328-1  
HINGE PLATE  
(TYP BOTH ENDS)



VIEW A-A

*7/27/04*



DETAIL D  
(SCALE 1:2)

**DEO ATTACHED**  
**RELEASED**  
05.04.28 *#*

W/O:		WORK ORDER CHANGES					
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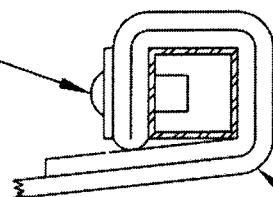
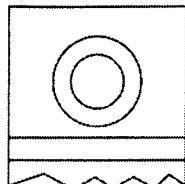
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3325	REV. B SHEET 3 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

MS20600AD4W3 RIVET (1)  
AN960JD9 WASHER (1)



DETAIL B  
TYP. ATTACHMENT OF WEBBING TO LID  
FRAME  
(SCALE 1:1)

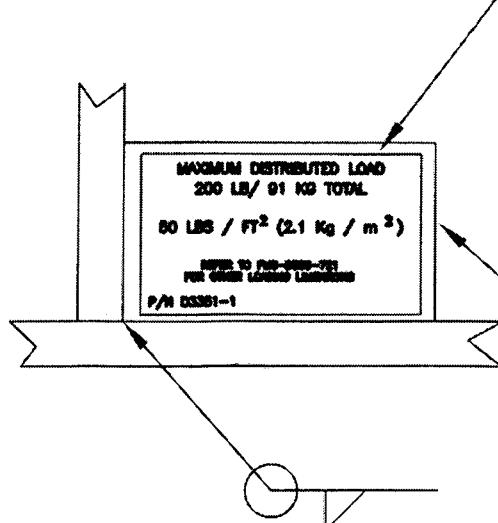
D3320-041 WEBBING

RELEASED  
05-04-28 *PH*  
DETACHED

ATTACH D3351-1 PLACARD  
ON TOPSIDE OF D3352-1

*7/27/05*

OUTBOARD



D3352-1

IDENTIFY WITH DART P/N  
D350-721-041 USING  
D2729-1 PRODUCT ID LABEL  
INSTALLED ON UNDERSIDE OF  
D3352-1

DETAIL C  
LABEL PLATE ATTACHMENT  
(SCALE 1:2)

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W/O:		WORK ORDER CHANGES					
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DRAWING NO. D3325	TITLE BASKET LID ASSEMBLY	REV. B	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>		D.E.O. NO. D3325-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN DATE 08.11.28	AJS	CHECKED	MFG. APPR.	APPROVED	DE APPR.		
			08.11.28	08.12.01	08.12.01	08.12.01	

1) SHEET 1 MODIFY PARTS LIST AS SHOWN:

7/27/08

**PART LIST FOR D3325-041 BASKET LID ASSEMBLY**

Part No.	Quantity	Description

IS:

MS20600AD4W5	32	RIVET

WAS:

MS20600AD4W3	32	RIVET

2) UPDATE SHEET 3 DETAIL B ACCORDINGLY.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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